Work Orde								H-Lade		******	<u> · · · · · · · · · · · · · · · · · · </u>	Page 1
Revision ID:	D4016-1 Hinge Half, Ba	ase		Accept					Setup	Start Stop		
Start Date: Required Date: Reference:	8/5/2010 8/12/2010	Start Qty: 9.00 Req'd Qty: 9.00	† 1881/18 181/1881 † 1881/18 181/1881		Cust Item } Customer:	D:				-	1 18813181 B	IBIB 118 (181 188)
Approvals:	Process Pla QC:	n:	Date: 10-8-04 Date:	Tooling: SPC (Y/N):		ate:				Start Stop		
Sequence ID/ Work Center II)	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reje Qty		Reject Number	Insp. Stamp
Draw Nbr	Revi	ision Nbr			- "1							
D4016	A											
Bandsaw Jeaspa Bandsaw		Cut blanks as per folio Memo CUT BLAN	JK 1.00" LONG	0.00 ONL	Liolo 8/11			9		B		
110 		Memo		0.00		y .		9	po			·

and10/08/15

DEBURR

MACHINE AS PER FOLIO FA869 AND DWG FOLIO REV: A DWG REV: A

Memo

HAAS CNC vertical machine #1

W/O:			WO	RK ORDER CHANG	GES				₹
DATE	STEP	PRO	OCEDURE CHAN	GE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
								Prod Mgr	
Part No	:	PAR #:	Fault Categ	ory:	NCR: Yes 1	No DQA	۸:	Date: _	
		esolution:							
NCR:			WORK ORDE	R NON-CONFORM	IANCE (NCR)				
DATE STED		Description of NC	(ction B	Verific	ation	Approval	Approval	
DATE	DATE STEP Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section		Chief Eng	QC Inspector	
				,					
			•						

Work Order ID 61062

Thursday, August 05, 2010 10:11:18 AM



Page 2

Item ID:

D4016-1

Accept



Setup Start



Revision ID:

Item Name: Hinge Half, Base

Required Date: 8/12/2010

Start Date:

8/5/2010

Start Qty: 9.00

Req'd Qty: 9.00



Cust Item ID:

Customer:

Reference:

Approvals:

QC:

Process Plan:

Date:_____

Date: _____

Tooling:

SPC (Y/N):

Date: Date: Run

Start Stop

Stop

Sequence ID/ **Work Center ID**

120

Quality Control

Operation **Description**

QC2- Inspect parts off machine FAI/FAIB

Set Up/ **Run Hours**

0.00

Tool ID

Tool # Plan Code

Accept Qty

Reject Qty

Reject Number Stamp

Insp.

Memo

0.00 and 10/08/15

130

QC

QC8- Inspect parts - second check

0.00

D. A 10/08/15

Quality Control

Memo

Identify as per dwg & Stock Location

0.00

160

Packaging Packaging

Memo

Steve

0.00

0.00

Dart Ae	rospace Lt	d							
W/O:			WC	ORK ORDER CHANGI	ES				۲
DATE	STEP	PRO	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
			•						
Part No	:	PAR #:	Fault Cate	gory:	NCR: Yes	No DQ	۹:	Date: _	
	Reso	lution:	Dispositio	n:	_ QA: N/C C	losed:		Date: _	
NCR:			WORK ORD	ER NON-CONFORMA	NCE (NCF	R)			
DATE	STEP	Description of NC		Corrective Action Section		Verific	ation	Approval	Approval
DAIE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign of Date	Secti		Chief Eng	QC Inspector
	1				[

Work Order ID 61062

Thursday, August 05, 2010 10:11:18 AM



Page 3

Item ID:

D4016-1

Accept

Setup Start



Revision ID:

Item Name:

Hinge Half, Base

Start Date:

Required Date: 8/12/2010

8/5/2010

Start Qty: 9.00

Req'd Qty: 9.00



Cust Item ID:

Customer:

Reference:

Approvals:

QC:

Process Plan:

Operation

Date:

Date: SPC (Y/N):

Tooling:

Date:

Date:

Run

Start

Stop



Stop



Sequence ID/

Work Center ID

Description QC21- Final Inspection - Work Order Release Set Up/ **Run Hours**

0.00

Tool ID

Tool # Plan Code

Accept Qty

Reject Qty

Reject Insp. Number Stamp

170

Quality Control

Memo

0.00

*
roval Eng / Mgr Approval QC Inspector
ļ
ate:
ate:

NCR:	:	WORK ORDER NON-CONFORMANCE (NCR)										
		Description of NC		Corrective Action Section B	Verification	Approval	Approval					
DATE	STEP	Section A	Initial Chief Eng			Sign & Section C		QC Inspector				
				•								
			2.	,								
						!						

Picklist Print

Thursday, August 05, 2010 10:11:22 AM

Work Order ID: 61062

Parent Item:

D4016-1

Parent Item Name: Hinge Half, Base



Start Date: 8/5/2010

Required Date: 8/12/2010

Page 1

Start Qty: 9.00

Required Qty: 9.00

Comments:

IPP REV:A NEW ISSUE 09-11-27 JLM VERIFIED BY DD

		,			 	1 1001.	
per dwg REV.A	DD 1	10.02.22	verified	by:EC			

Y	Replacement tem ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304B1.500X1.500		Purchased	No			100	f	6.4704	0.08	0.757895			

304 bar 1.50 X1.50

Location Loc Oty Loc Code MAT54 6.47040368 108381 5.8123 112752 0.65810368

.75789 al 10/08/11

W/O:			WO	RK ORDER CHANGE	ES				1
DATE	STEP	PRO	OCEDURE CHAN	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No		PAR #:	Fault Categ	ory:	NCR: Yes	No DQ	A:	Date: _	
	R	esolution:	Disposition	:	QA: N/C C	losed:		Date: _	
NCR:			WORK ORDE	R NON-CONFORMA	NCE (NC	R)			
DATE	STEP	Description of NC	ļ	Corrective Action Section		Verifi	cation	Approval	Approval
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date	& Sect	ion C	Chief Eng	QC Inspector
									,

DART AEROSPACE LTD	Work Order:	4062
Description: Hinge Half, Base	Part Number:	D4016-1
Inspection Dwg: D4016 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.875	+/-0.010	878			Vern	ML-7
0.25	+/-0.030	.240	\		M	()
0.38	+0.030/-0.000	.394			11	f t
R0.03	+/-0.030	R. 030			R.G	
0.13	+/-0.030	.125			Ven	ML-7
0.88	+/-0.030	877	·		1 (11
Ø0.257	+0.006/-0.001	0.258			11	(/
R0.38	+/-0.030	R.375			R-6-	
0.500	+/-0.030	.500			Vem	ML-7
0.75	+/-0.030	757			15	, , ,

Measured by:	and	Audited by:	S.A	Preliminary Approval:	
Date:	10/08/14	Date:	10/08/15	Date:	

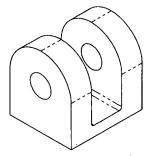
Rev	Date	Change	Revised	Ρ/ /\	Approved
A 1	0.06.07	New Issue	KJ c	 	

Dart Ae	rospace L	td							
W/O:			W	ORK ORDER CHANG	GES				
DATE	STEP	PROCEDURE CHANGE				Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	·	PAR #:	Fault Cate	gory:	NCR	:Yes N	lo DQA:	Date: _	
	Res	olution:	Dispositio	n:	QA:	N/C Clos	sed:	Date: _	
NCR:			WORK ORD	ER NON-CONFORM	IANCE	(NCR)			
		Description of NC		Corrective Action Section B			Verification	Approval	Approval
DATE	STEP	Section A	Initial	Action Description		Sign &	Section C	Chief Eng	QC Inspector

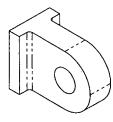
NCR:			WORK ORD	ER NON-CONFORMANC	E (NCR)			
		STED Description of NC		Corrective Action Section B		Verification	Approval Chief Eng	Annroyal
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C		Approval QC Inspector
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					:			

SHOP COARCE
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ENGINEERING
UNCONTROLLED CO.
SUBJECT TO AMERICA.
WITHOUT NOT A T
WORE OR (A.S.
NO.

PP10-



D4016-1 HINGE HALF, BASE



D4016-3 HINGE HALF, LID

D4016-5 HINGE HALF, LIGHT LID

RELEASED 2010 -02- 16

Α	NEW IS	SUE	JPH	10.01.29				
REV.			DESCRIPTION	BY	DATE			
DESIGN AJS		AJS	DART AEROSPACE LTD					
DRAW	١ .	AJS	HAWKESBURY, C					
CHECKED (a	DRAWING NO.		REV. A			
MFG. APPR.		12	D4016		SHEET 1 OF 2			
APPRO	VED	140	TITLE		SCALE			
DE APPR.		4	BASKET HINGE	NTS				
DATE	10.0	1.29	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IN HIS DOCUMENT OF HIS MOST OF THE STREET OF TH					

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
-									
Part No		PAP #· Fault Category:	NCD: Voc	No DO	۸.	Date			

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:			WORK ORDER NON-CONFORMANCE (NCR)								
		Description of NC		Corrective Action Section B		Vidiali					
DATE	STEP Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector				
				·							
						}					

0.875 0.25 0.38+0.03 R0.38 Ø0.257 REF THRU GRAIN DIRECTION 0.88 0.50 0.13 R0.03 TYP 0.75

D4016-1 HINGE HALF, BASE

NOTES: 1) MATERIAL -1 & -3: 304/316 STAINLESS STEEL BAR, PER ASTM A276 REF DART SPEC M304B

-5: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR, PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS4117/4128/4115/4116) OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160) OR ASTM B211 OR ASTM B221 REF DART SPEC M6061T6B

- 2) FINISH: NONE
 3) TOVERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: NONE
 7) WEIGHT -1: 0.09 lbs
 -3: 0.04 lbs
 -5: 0.01 lbs

-5: 0.01 lbs

do 61062 GRAIN DIRECTION - 0.88 0.13 0.250 0.50 R0.03 0.563 ---R0.31 REF 0.63 Ø0.257 THRU

> **D4016-3 HINGE HALF, LID D4016-5 HINGE HALF, LIGHT LID**

D

DESIGN AJS		DART AEROSPACE LTD				
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA				
CHECKED	W	DRAWING NO.	REV. A			
MFG. APPR.	12/2	D4016	SHEET 2 OF 2			
APPROVED	10	TITLE	SCALE			
DE APPR.	_#	BASKET HINGE	NTS			
DATE 10.0	1.29	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIMATE AND CONFECURITY, AND IS SUPPLED ON THE EXPRESS CONDITION THAT IT IS NOT TO SE VISED FOR ANY PAYANGES OF COPPED OR COMPANIANCE TO TO ANY OTHER PERSON WITHOUT				

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W/O:		WORK ORDER CHANG	ES				
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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	-						
					•		

Part No:	PAR #:	Fault Category:	NCR: Yes No DQA:	Date:
	Resolution:	Disposition:	QA: N/C Closed:	Date:

NCR:		WORK ORDER NON-CONFORMANCE (NCR)								
		Description of NC		Corrective Action Section B		Verification	Approval Chief Eng	Approval QC Inspector		
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C				
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